

Work Order ID 57951

April 21, 2010 8:42:36 AM



Page 1

Item ID: D3547-1

Accept



Setup Start



Revision ID:

Item Name: Bracket

Stop



Start Date: 21/04/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 28/04/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 10-4-21

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3547

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3547 ☐ Dwg Rev: A

☐ Prog Rev: A

☐

****Ensure Grain Direction is Correct**** ☐ 2-Debur if necessary

6061 - 125

10-5-6

14

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

10-5-6

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

8.10/05/06

7/14

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Page 2

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00



Brake NC

NC BRAKE

Memo

0.00

8 10/05/07

Brake NC

Bend as per Dwg D3557

140

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

5 10/05/07

Quality Control

(44)

150

0.00



HandFinish

Chemical Conversion Coat per QS1005 4.1

Memo

0.00

7 M-k 10/05/07

Hand Finishing

(142)

W/O:		WORK ORDER CHANGES					
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Page 3

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Required Date: 28/04/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

8:00am

OVEN TEMPERATURE:

8:30pm FINISH TIME:

320°F

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

180

Identify as per dwg & Stock Location:

069

0.00



Packaging

Memo

0.00

Packaging

14

BR 10-5-11

10/5/11 14

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 4

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/12

BS10-5-11

(12)

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

April 21, 2010 8:42:41 AM

Page 1

Work Order ID: 57951



Parent Item: D3547-1



Parent Item Name: Bracket

Start Date: 21/04/2010

Required Date: 28/04/2010

Comments: IPP Rev:A New Issue 06-09-18 JLM

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.125		Purchased	No				sf	189.2000	0.6695	.8		
6061-T6 .125 Sheet												

B10-5-6

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT21	189.2	
112476	19.2	
113424	10	
113608	96	
114352	64	

(14)

113424

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DART AEROSPACE LTD		Work Order:	57951
Description: Bracket		Part Number:	D3547-1
Inspection Dwg: D3547	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.313	+/-0.010	.316	✓			
0.913	+/-0.010	.913	✓			
2.054	+/-0.010	2.054	✓			
2.38	+/-0.030	2.377	✓			
0.438	+/-0.010	.439	✓			
2.813	+/-0.010	2.815	✓			
0.575	+/-0.010	.572	✓			
1.100	+/-0.010	1.105	✓			
1.625	+/-0.010	1.625	✓			
2.150	+/-0.010	2.157	✓			
2.675	+/-0.010	2.677	✓			
3.25	+/-0.030	3.251	✓			
Ø0.172	+0.005/-0.001	.176	✓			
Ø0.323	+0.006/-0.001	.326	✓			
0.125	+/-0.010	.124	✓			

Measured by: KB	Audited by: S	Prototype Approval:	N/A
Date: 10-5-6	Date: 12/05/06	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.03.21	New Issue	KJ/JLM	BE

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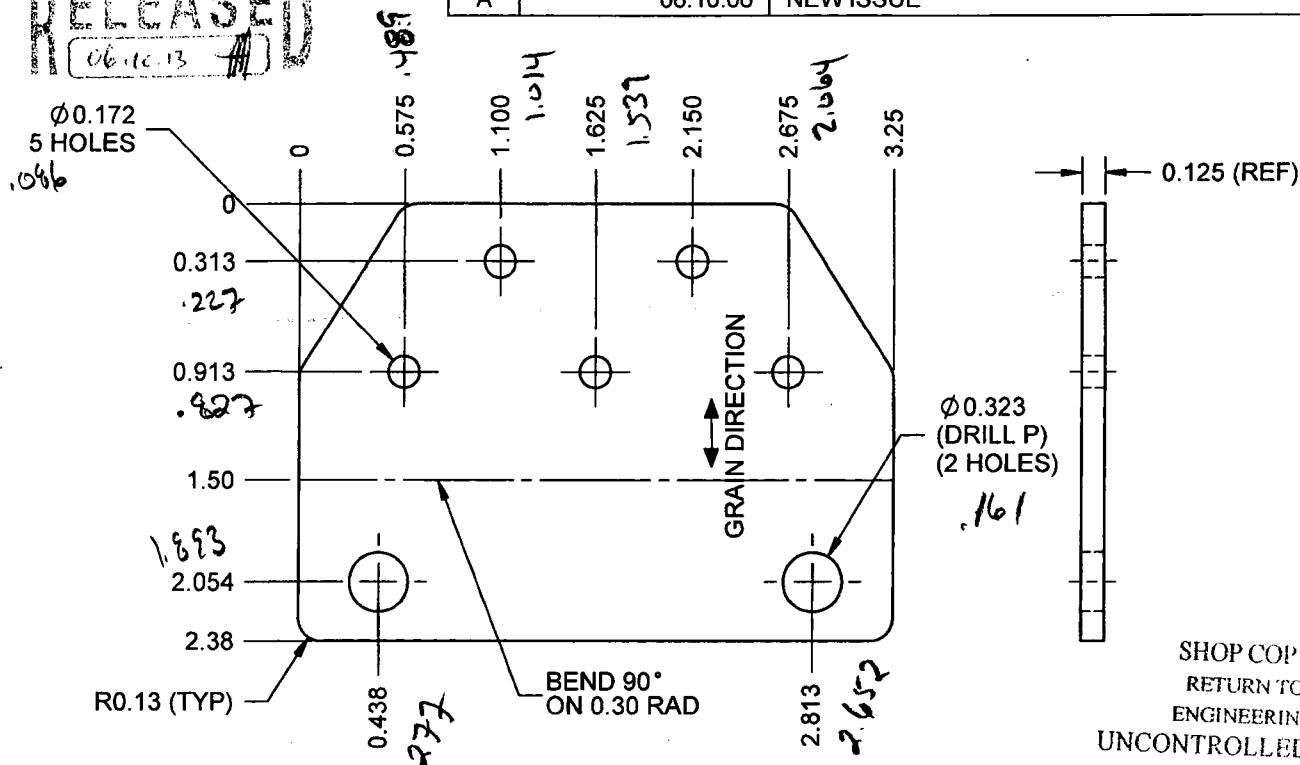
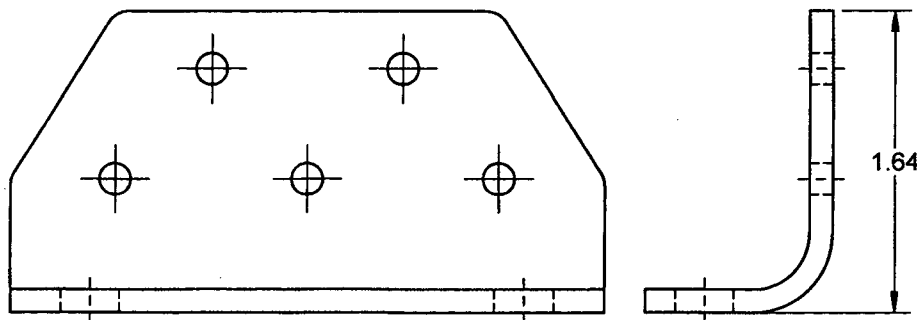
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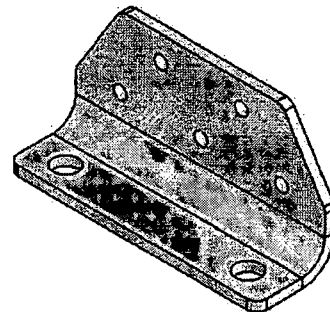
NOTE: Date & initial all entries

DART

DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3547	REV. A SHEET 1 OF 1
DATE 06.10.06		TITLE BRACKET	SCALE 1:1
REV A	DATE 06.10.06	DESCRIPTION NEW ISSUE	

RELEASED
06.10.13**D3547-1F FLAT PATTERN****D3547-1 BRACKET****NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM 0.125 THICK PER QQ-A-250/11 (REF DART SPEC M6061T6S.125)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) IDENTIFY WITH P/N D3547-1 USING FINE POINT PERMANENT INK MARKER



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *57951*

MS 10-4-21

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